

Work Order ID 81047

Wednesday, March 07, 2012 11:09:55 AM

81047

Page 1

Item ID: D2280

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Spacer

Stop ***NS2***

Start Date: 3/7/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/16/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 12-03-07 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2280	Rev D								
100		0.00							
100	SHEAR								
Shear	Memo	0.00							
Shear	Cut blank: (3.400") +/-0.020"		<i>SL</i>	12-03-08					<i>(4)</i>
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine per folio D2280 and Dwg D22802-Deburr Then Tumble		<i>SL</i>	12/03/09					<i>(4)</i>
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control			<i>SL</i>	12/03/09					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Spacer

Start Date: 3/7/2012 Start Qty: 4.00

Required Date: 3/16/2012 Req'd Qty: 4.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

12/3/9

Ae 12.03.10

3/13

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

160

Identify as per dwg & Stock Location: _____

0.00

160

Packaging

Memo

SHIP
PO 7445

0.00

Packaging

6/4/13 (4)

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

12/3/13

W1203.13

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Picklist Print

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Page 1
1

Work Order ID: 81047

Parent Item: D2280

Parent Item Name: Spacer

Start Date: 3/7/2012

Required Date: 3/16/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-07 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X01.000 6061-T6 Bar .250 x 1.00		Purchased	No			100	f	77.7200	0.2833	1.1928421			

Location

Loc Qty

Loc Code

Mezz

77.72

103039

24.82

18237

10.9

19059

42

SL 12-03-08

1-2

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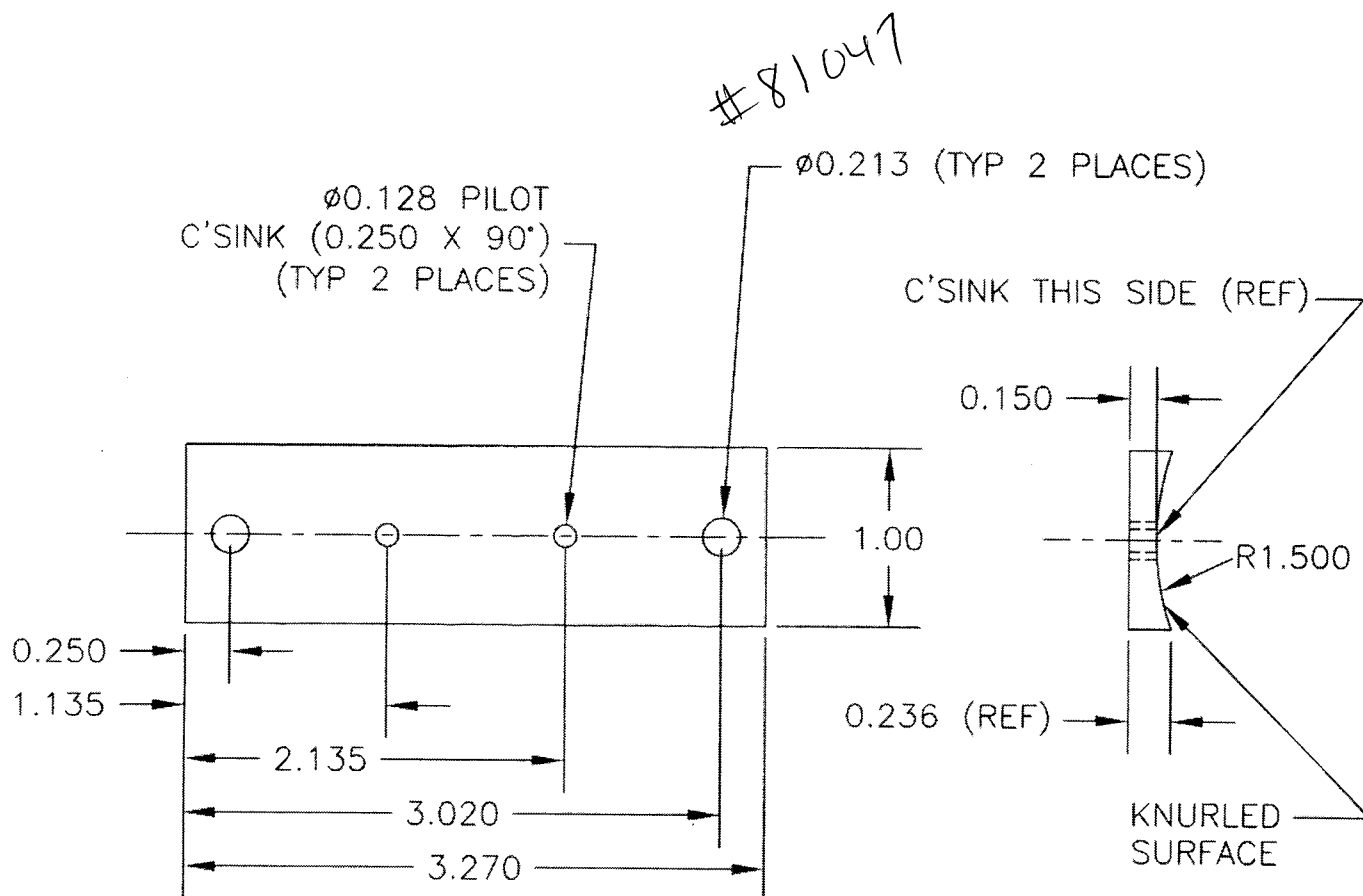
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DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2280	REV. D SHEET 1 OF 1
DATE 05.11.14		TITLE SPACER	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.22	MATERIAL CHANGE, 0.15 WAS 0.20	
C	98.09.29	0.188 DIA HOLE CHANGED TO 0.213	
D	05.11.14	ADD FINISHING NOTE	

RELEASED
05.11.28 #



D2280 SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8) BAR, 0.250 X 1.000
(REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

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